

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019153**Date Inspected:** 09-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

**MAGNETIC PARTICLE TESTING**

ZPMC NWIT No: 08105

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this date. The members are identified as OBG 13AE. The weld designations are as follows:

SEG3007Y-072, 076, 080, 084, 088, 092, 053, 055, 057, 059, 061, 063, 068, 074, 075, 078, 079, 082, 083, 086, 087, 090, 091, 094, 095

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068501 performing the Flux Cored Arc

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Welding process on weld 274 located at PCMK SEG3019H. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066443 performing the Shielded Metal Arc Welding process on weld 077 located at PCMK SEG3019L-1. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2643.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067665 performing the Shielded Metal Arc Welding process on weld 127 located at PCMK SEG3019X. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 323 located at PCMK SEG3019D-1. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-ESAB-Repair-Fcm. Critical weld repair report identified as B-CWR2678.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044830 performing the Flux Cored Arc Welding process on weld 013 located at PCMK SEG3019K-1. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-ESAB-Repair-Fcm. Critical weld repair report identified as B-CWR2667.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201087 performing the Shielded Metal Arc Welding process on weld 145 located at PCMK SEG3019BB. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070007 performing the Shielded Metal Arc Welding process on weld 015 located at PCMK SEG3019Z. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Weld repair report identified as B-WR19723.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066422 performing the Shielded Metal Arc Welding process on weld 013 located at PCMK SEG3019Z. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Weld repair report identified as B-WR19725.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant
<b>Reviewed By:</b>	Patterson,Rodney

Quality Assurance Inspector

QA Reviewer

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